



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G26551-3G

Job Sheet 171440



Part No: RBW6205G26551-3G

Job Qty: 1 ea

Part Name: Main Rotor Scissor Locknut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/8/18	0.00	0.00	Start Up Small Fab-2		MU
110	Small Fab	1 pcs		2/9/18	0.00	0.20	Small Fab-3		MU DAS
120	QC	1 pcs		2/9/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		2/9/18	0.00	0.00	Packaging3-1		GA092 9-88
140	QC21-FG	1 Ea		2/9/18	0.00	0.00	QC21		MAR 2 2 2018

Part Op
Descriptions: 110 - -Package case as per DWG sheet 1

DAS
21
9-88

MAR 2 3 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1030-E	Case	1 Ea (1 ea)	90-Start up Operation	
RBW6205G26551-3G-1	Main Rotor Scissor Locknut	1 Ea (1 ea)	90-Start up Operation	
RBW6205G26551-3G-5	Bottom Foam	1 Ea (1 ea)	90-Start up Operation	
RBW6205G26551-3G-7	Top Foam	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	APP-1030-E 893	1	0	0
	RBW6205G26551-3G-1 96	1	0	0
	RBW6205G26551-3G-5 93	1	0	0
	RBW6205G26551-3G-7 93	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

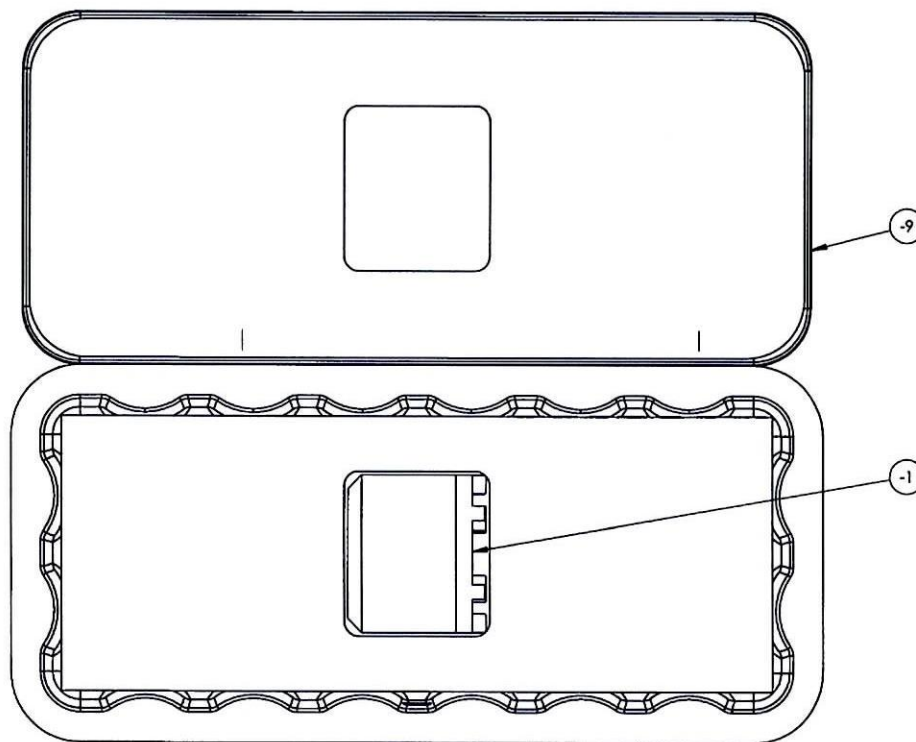
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-1 Machi Thermoform Large		ring ality ther																																																					
Date :		Step #:		QTY E		) Approval																																																					
Description Work Order Deviation																																																											
						ed By Supervisor rification rdinator val																																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> <tr> <td style="width:15%;">Environment</td> <td>☐</td> <td style="width:15%;">No Re-verification</td> <td>☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> </table>								Root Cause				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
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Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter		Temperature/C Set-up BOM/Route Broken/Damag Inspection Inco Contamination Countersink Cut Too Short Instructions Inco Drill Holes		Date: 03/19/18 Inspector: Revision: 8 Serial No/Batch: S052661 Job No: 171440 Part: RBW6205G26551 - 3G Container No: S052661 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																							
OTHER : _____																																																											

Wrong
 nensions
 - tolerance
 ect
 lissing

Misaligned/off center Turning Sequence

ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-1	1	RBW6205G26551-3G-1	M/R SCISSOR LOCKNUT	2	1	RELEASED FOR PRODUCTION	-	4/13/2015	C	JAG
-9	1	RBW6205G26551-3G-9	PACKAGING ASSY	3	B	TEMPLATE UPDATED, ASSY -9 PACKAGING ADDED	17-796	17.12.20	VM	ML



RBW6205G26551-3G MAIN ROTOR SCISSOR LOCKNUT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171440 MJS
18-02-01

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE MAIN ROTOR SCISSOR LOCKNUT	
PART NO. RBW6205G26551-3G	REV B
TOOL NO. RBW6205G26551-3G	
DETAILS AND DATE	
DESIGNED BY: VM 17/12/20	TOLERANCES: XXX 2.005 FRACTIONS 2 1/8
DRAWN BY: VM 12/20/2017	XX 2.01 ANGLES 2.5°
CHECKED BY: ML 12/21/2017	X 2.1 SURFACE ROUGHNESS
INFO REVIEW BY: DD 01/02/2018	SCALE: NTS SHEET 1 OF 6
APPROVED BY: ML 01/04/2018	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
UNCONTROLLED REVISION CONTROL				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					